

17/09

Date: Tuesday, 9/11/2007 10:56:36 AM
 User: Chantal Lavoie

Process Sheet

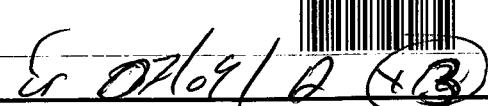
Customer	: N/A		Drawing Name	: COVER		
Job Number	: 34544		Part Number	: D36414		
Estimate Number	: 12963		Drawing Number	: D3641 UNDER REVIEW		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 9/11/2007		Drawing Revision	: U/R		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 9/18/2007		
Previous Run	: N/A		Qty:	12	Um:	Each
Written By	: <u>JL</u>					
Checked & Approved By	: <u>JL</u>					
Comment	: Est Rev:A New Issue 07-07-20 JLM		Verified By:EC			

Additional Product

Job Number:



244

Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6S032	6061-T6 Sheet 0.032"	
Comment: Qty.: 0.8244 sf(s)/Unit Total : 9.8923 sf(s) M6061-T6 .032" THK sheet Batch: m16954 HB 07-09-12			
			
2.0	WATER JET	FLOW WATER JET	
Comment: FLOW WATER JET 1-Cut as per Dwg D3641 Dwg Rev: A HB 07-09-12 Prog Rev: A 			
2-Deburr if necessary			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
HB 07-09-12			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK			
5.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE Form as per Dwg D36415			
			
HB 07/09/13			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.09.12	5.0	120° ANGLE NOT ACHEIVED 2.50 IS 2.67	VE 07.09.12	ACCEPTABLE PART WILL FUNCTION IN SERVICE AS INTENDED. NOT A STRUCTURAL PART.	VG 07.09.12	Sp 07.09.12 (Q51 042)	VE 07.09.12	NO 07.09.13

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:56:36 AM
User: Chantal Lavoie

Process Sheet

Customer:

Drawing Name: COVER

Job Number: 34544

Part Number: D36414

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ex 07/04/13 (+13)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(P)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL

07-09-14

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ex 07/04/14 (X/13)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



POSITIVE
RECALL

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

11/01/15 SV

13x ENGINEERING ^{VE} APPROVAL ^{07.09.14} (13)

D 07/16/2015

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ct 07-09-14
POSITIVE RECALL
EFFECTIVE 07.09.13 AUTH U
RELEASED VE DATE 07.10.15
U

Job Completion

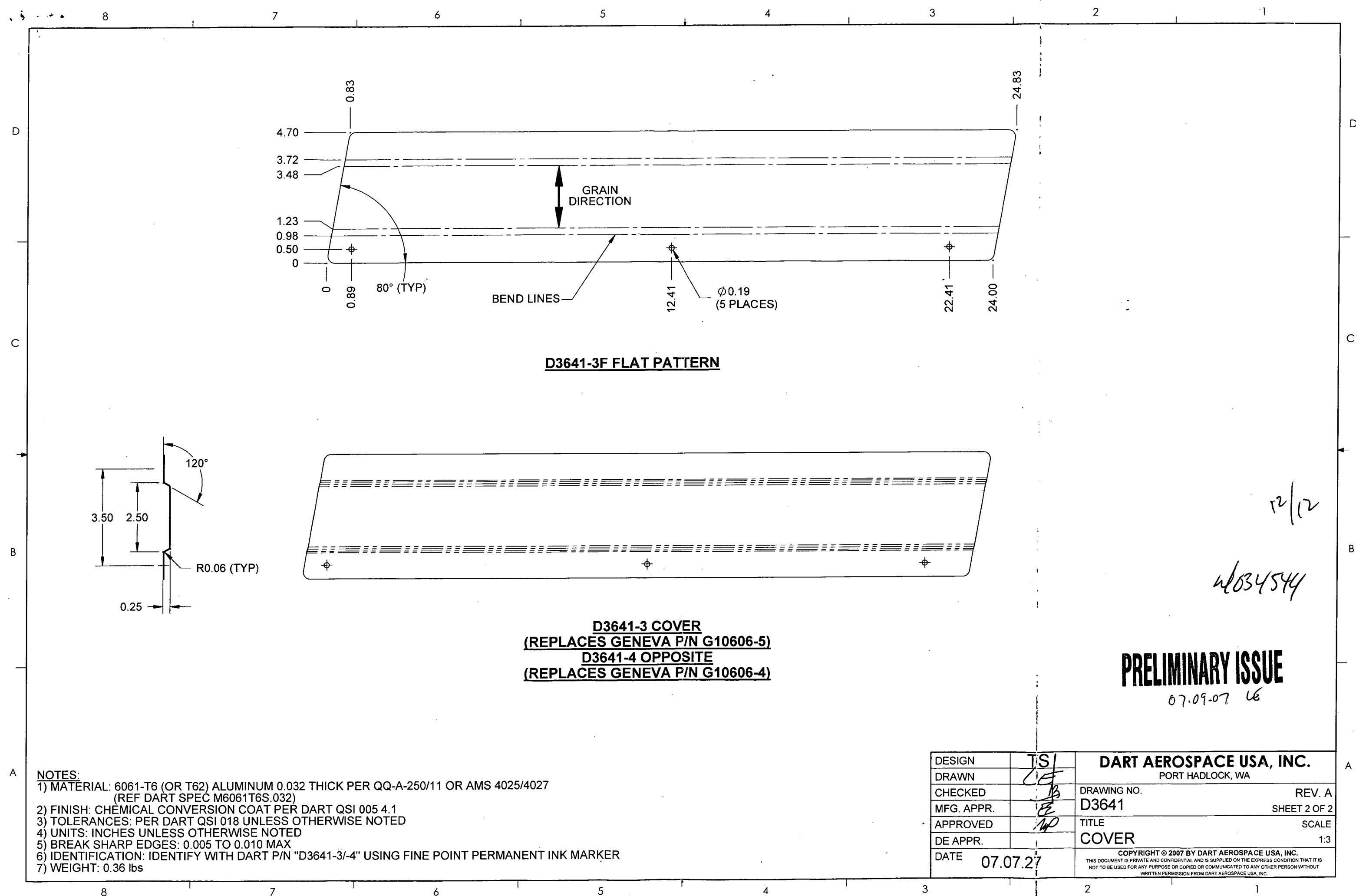


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD	Work Order:	34544
Description: COVER	Part Number:	D3641-4
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>IB</u>	Audited by: <u>6</u>	Prototype Approval: <u>UE</u>
Date: <u>07-09-12</u>	Date: <u>07/09/12</u>	Date: <u>07.09.12</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

10

Non-Conformance Report

NCR

08-112

Raised by:	Jason Murdoch	Source:	Q.C. Inspection	Sheet No. _____ of _____
Non-Conforming	Dept./Supplier: Prod - Packaging stoves			Date: 08-11-12
Product/Service:	Shoulder harness kit (D350-764-011) D3641-3 & -4			Priority: HIGH LOW

Area of Standard:	Section A
QSI	Description of Non-Conformance: The -3 and -4 parts were mixed up & not identified correctly. They were stocked & identified as the opposite.
QSP	See also WRO D350-764-011 B 43227
QSPM	
Documents:	
P/O	
Invoice	
W/O	
Batch No.	34543 & 34544
TSR	Root Cause: The drawing was not verified when identifying the parts for stock. Lack of attention.
Drawing	D3641.

REFERENCE ONLY

Forward to Director, Quality Assurance on completion of Section A

DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion of C/A.

Section B Corrective Action

Responsible for Investigation/CA: L. Lacelle.

To be done by: 08-11-20

No	Initial	Action Description	Responsible	Due date	Sign/Date
1	J.M	Determine affected kits. None in stock of the D350-764-011	L. Lacelle	08-11-12	08-11-12
2	J.M	Quarantine all stock. Note: 1x D3641-3 was found charged in wrong above.	J.M.	08-11-12	08-11-12
3	J.M.	Re-identify stock: Qty 1 -4 B34544 → now -3 B 34543	J.M.	08-11-12	08-11-12
4	J.M.	Ensure all Employee's are aware to verify the drawing in relation to the part when identifying, and to ask questions if they are uncertain of the views on the drawing. Re-train the employee's on how to interpret the drawing, and views.	J.M.	08-11-12	08-11-12
5	J.M.	Attack a copy of the NCR & the original copy of all the affected W/O's.	J.M.	08-11-20	08-11-20

Fault Category:

Prod - Stoves packaging

Section C Verification of C/A

Responsible for Verification of CA: S. Sheld

No	Verification Method	Sign	Date	Forward to DQA on Completion of Verification
1				
2	Discussed in Net Review			
3				
4	System in place to prevent recurrence	LL	08-11-20	DQA: _____
5				Date: _____

QA Purposes only

N/C Closed

Date